

Sup May 2

Work Order ID 67885

Monday, April 04, 2011 9:23:03 AM



Page 1

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	4/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/11/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>N</u>	Date:	<u>11-04-11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4042	A

100 Weld per dwg A/R S.S. rod Batch: M115928 0.00



Large Fab

Memo 0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

11-04-29

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

1 0 BE11/04/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Silhouette

(X)

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

m-f

11/04/2011

(IX)

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 2:45

OVEN TEMPERATURE: 400

FINISH TIME: 3:15

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

(1X)

m-k 11/04/29

N/116964

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD
11-04-29

(1)

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Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EB 11/05/02 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/02

⑩

170

Identify as per dwg & Stock Location G.A 0.00

Packaging

Memo

0.00

Packaging

w/o 67884

EB 11/05/02 ①

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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/348

CL11/05/02

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Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

32.0000

2

2



Mounting Bracket



Cpl 11.04.29

Location

Loc Qty

Loc Code

WA005

32

66500

10

66806

22

(2)

D3913-1

Manufactured

No

100

Each

2.0000

1

1



Rib



Cpl 11.04.29

Location

Loc Qty

Loc Code

WA006

2

66629

2

B68184 → (1)

D3913-15

Manufactured

No

100

Each

5.0000

1

1



Wide Handle Plate



Cpl 11.04.29

Location

Loc Qty

Loc Code

WA

3

67751

3

WA005

2

66695

2

B68176 → (1)

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3

 Rib

Manufactured No

100 Each

4.0000

1

1



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

4

65314

1

67475

3

B68185 → ①

D3913-7

 Rib

Manufactured No

100 Each

6.0000

2

2



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

6

65278

1

66435

5

B67982 → ②

D3913-9

 Hinge Rib

Manufactured No

100 Each

4.0000

1

1



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

4

66630

2

67126

2

B68186 → ①

D3916-041

 Rib Assembly

Manufactured No

100 Each

1.0000

2

2



Pl 11.04.29

Location

Loc Qty

Loc Code

WA

1

65921

1

B67983 → ②

D3916-5

 Light Rib

Manufactured No

100 Each

0.0000

3

3



B67979 → ① Pl 11.04.29
B68155 → ②

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Shop Packet Print

Page 2

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100 Each

31.0000

3

3



Hinge Half, Base



Pl 11.04.29

Location

Loc Qty

Loc Code

WA

18

66418

0

67473

18

WA005

13

66418

13

(3)

D4017-7

Manufactured No

100 Each

3.0000

1

1



Rib



Pl 11.04.29

Location

Loc Qty

Loc Code

WA005

3

66885

3

B67478

D4017-9

Manufactured No

100 Each

4.0000

2

2



Rib



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

4

66886

4

B67978

D4020-11

Manufactured No

100 Each

14.0000

2

2



End Mesh, Basket



Pl 11.04.29

Location

Loc Qty

Loc Code

WA

14

61306

1

67094

4

67458

9

(2)

Monday, April 04, 2011 9:23:10 AM

Shop Packet Print

Page 3

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each

21.0000

3

3



Handle Plate



Pl 11.04.29

Location

Loc Qty

Loc Code

WA

13

67474

13

WA005

8

66697

8

3

D4034-041 Manufactured No

100 Each

3.0000

1

1



Aft Upper Rib Assembly



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

3

66884

3

367980 -> 1

D4034-043 Manufactured No

100 Each

2.0000

1

1



Fwd Upper Rib Assembly



Pl 11.04.29

Location

Loc Qty

Loc Code

WA006

2

66883

2

367981 -> 1

M304EX0.75-16F Purchased No

100 sf

530.0526

33

33



Expanded Metal Flat SS



Pl 11.04.29

Location

Loc Qty

Loc Code

WA

530.0526

115012

150

117197

380.0526

M117455 -> 33.

Monday, April 04, 2011 9:23:10 AM

Shop Packet Print

Page 4

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No
Bolt

150 Each 34.0000 6



EP 4/11/05/02
M117313

Location Loc Qty Loc Code

ST351 34
116400 34

~~AN960JD8~~ NAS1149DN832J Purchased No
Washer
D2931 Manufactured No
Bumper

150 Each 0.0000 2



EP 4/11/05/02
EP 4/11/05/02

Location Loc Qty Loc Code

ST504 696
46064 696

D4021-5 Manufactured No
Blanking Plate

150 Each 9.0000 2



2
EP 4/11/05/02
B68261 (2)

Location Loc Qty Loc Code

WA005 9
67008 9

MS20600-AD4W3 Purchased No
Cherry Rivets

150 Each 931.0000 2



EP 4/11/05/02
2

Location Loc Qty Loc Code

ST321 494
111636 494
WA018 437
107939 437

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,099.000

6



6
EB 11/05/02

Nut

Location

Loc Qty

Loc Code

ST300

2099

116391

499

116540

800

116549

800

6

NAS1149F0332P

Purchased

No

150

Each

22.0000

12



12
EB 11/05/02

WASHER

Location

Loc Qty

Loc Code

ST275

22

18057

22

M 17317 (12x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

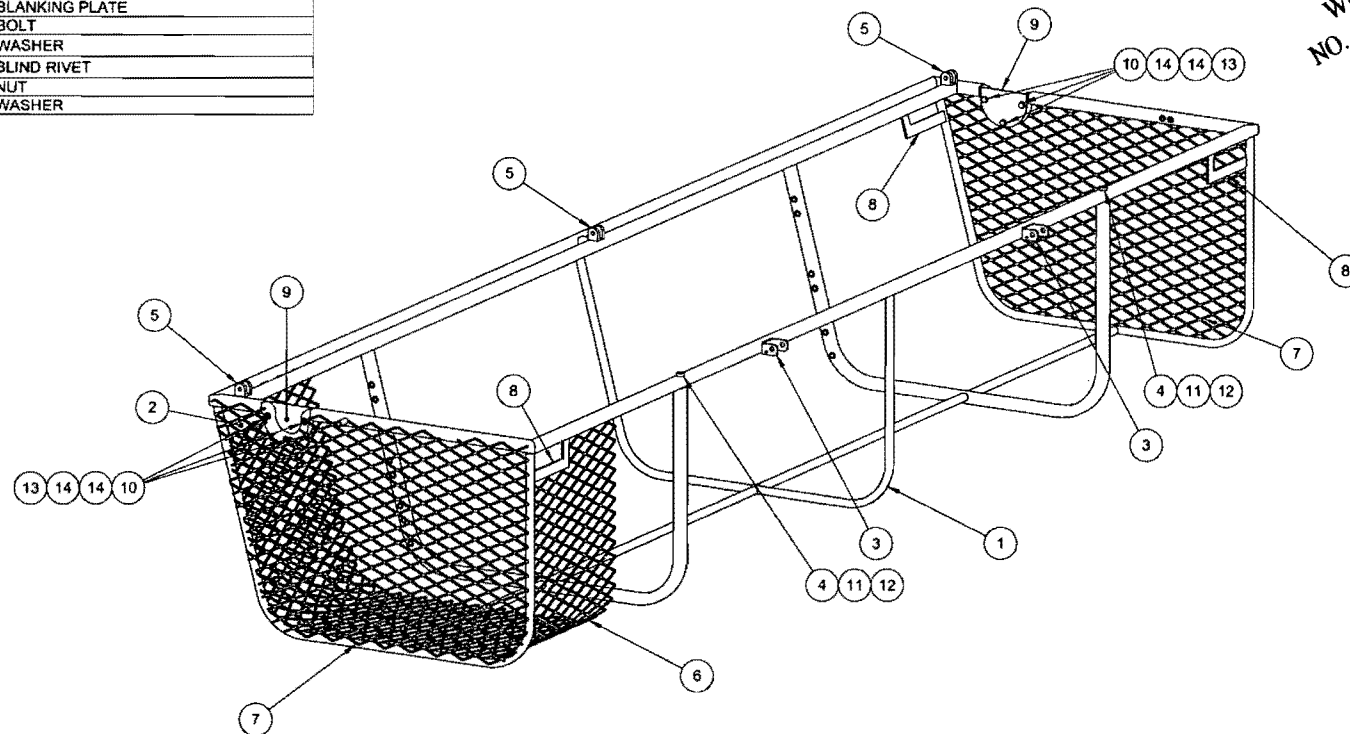
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47885
plough

RELEASED
2010-03-22
WJD

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	A.S		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3913
REV. A
SHEET 1 OF 6
TITLE LONG BASKET BASE ASSY (350) NTS
SCALE

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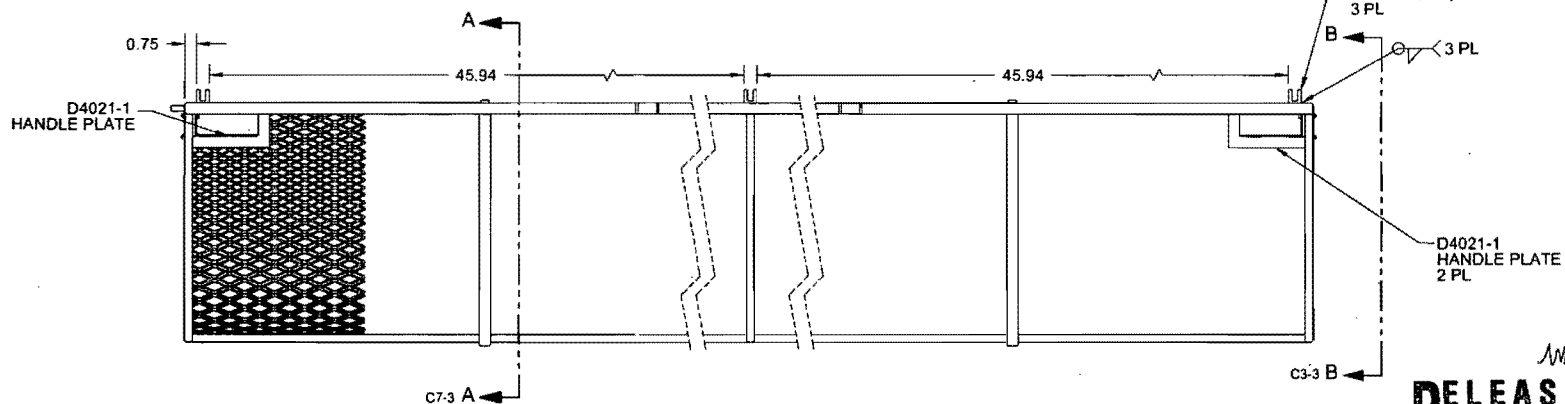
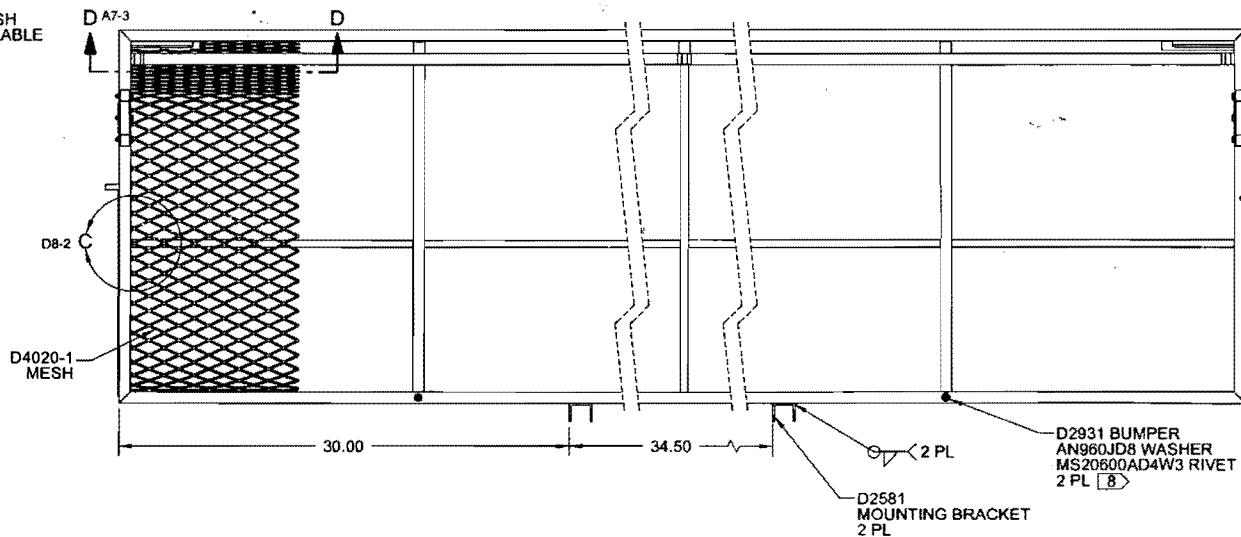
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

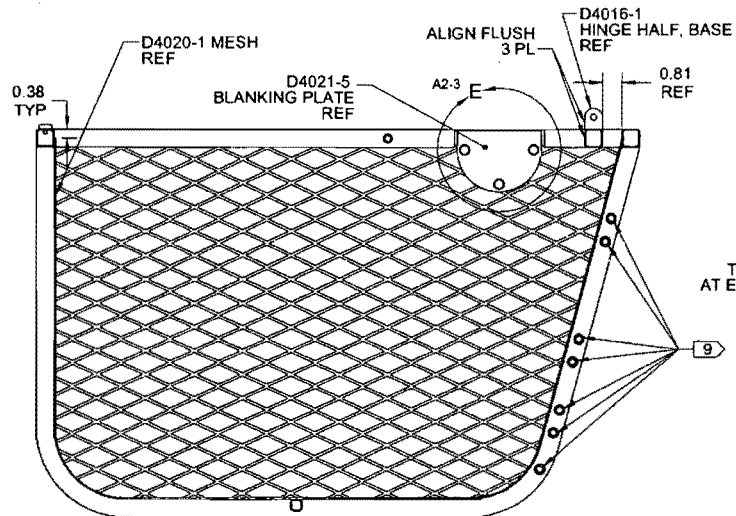
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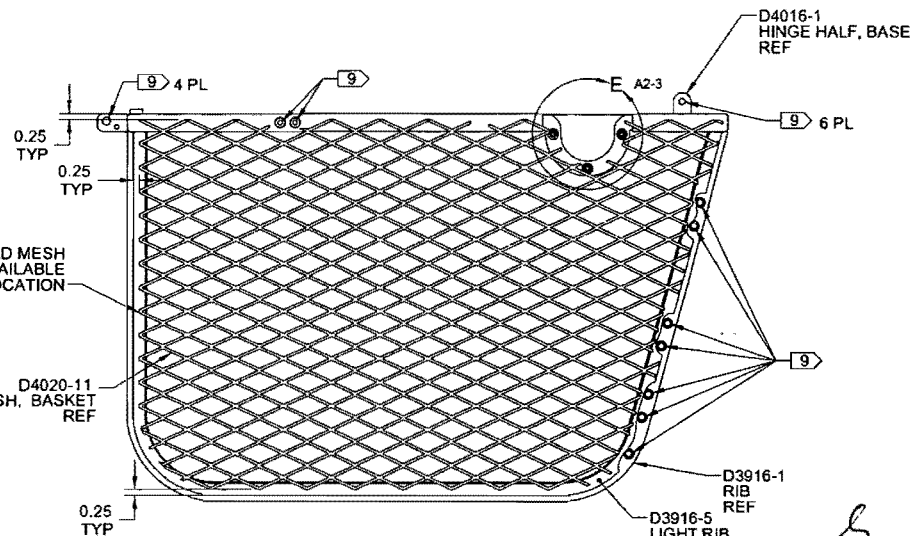
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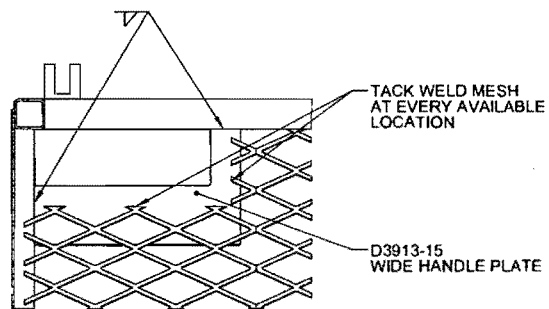
NOTE: Date & initial all entries



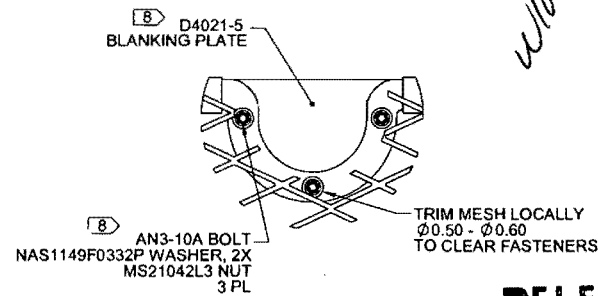
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

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2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

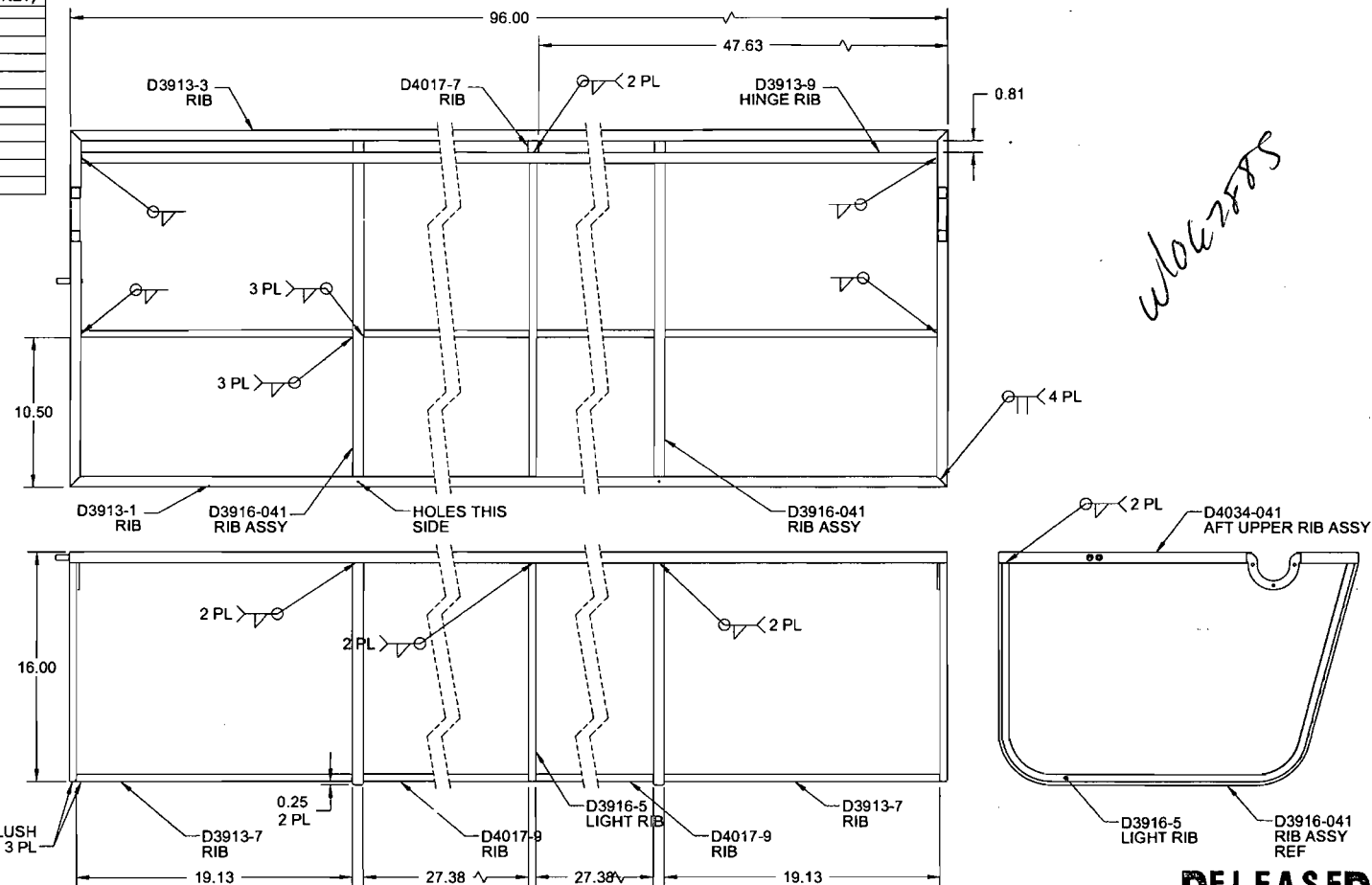
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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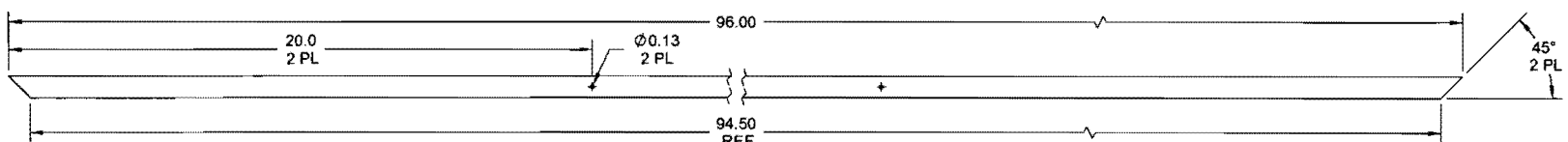
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

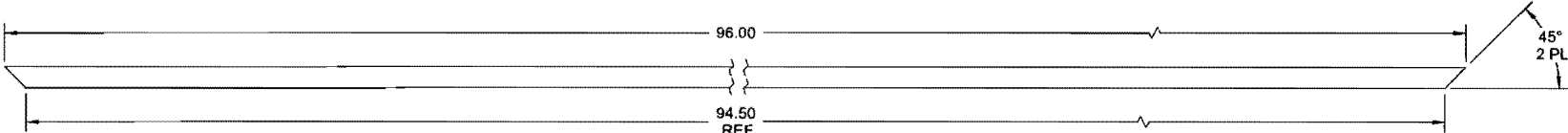
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

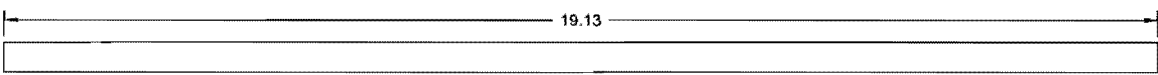
NOTE: Date & initial all entries



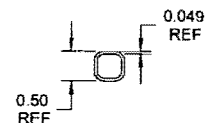
D3913-1 RIB



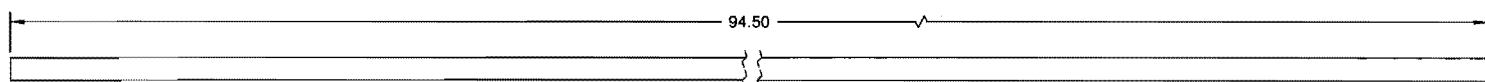
D3913-3 RIB



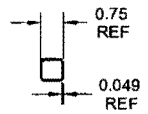
D3913-7 RIB



all sizes



D3913-9 HINGE RIB



NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
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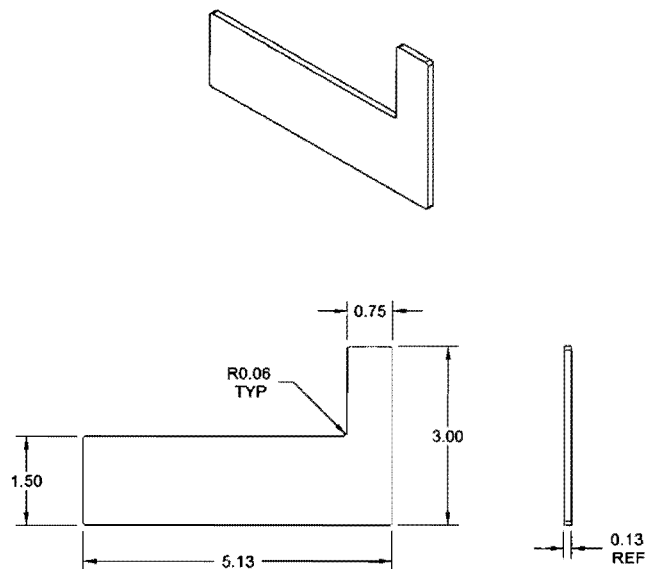
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries